

Date: Friday, 9/7/2007 10:14:55 AM  
 \* User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HINGE BRACKET, GAS SPRING
Job Number : 34465	
Estimate Number : 10179	
P.O. Number :	Part Number : D2144
This Issue : 9/7/2007 S.O. No. :	Drawing Number : D2144 REV. D
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : D
Previous Run : 33883	Material :
Written By :	Due Date : 9/14/2007 Qty: 20 Um: Each
Checked & Approved By : <u>9/07.09.07</u>	
Comment : Est: D 04.05.06 Reformat KJ/RF	
Est Rev:E Now on Waterjet 06-10-15 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	M304S16GA	304/316 .063 Sheet
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Comment: Qty.: 0.0945 sf(s)/Unit Total : 1.8900 sf(s)  
 304/316 .063 Sheet 16GA  
 Batch: M105130

SAD 03/09/08 24

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET  
 1-Cut as per Dwg D2144  
 Dwg Rev: D  
 Prog Rev: D

2-Deburr if necessary

SAD 03/09/08 24

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/09/08 24

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SA CA/09/10 counter (24)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1  
 Deburr if necessary

JLM 07/09/11 (24)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE BRACKET, GAS SPRING

#01

30 m

23/01/2008

S.00001 09.20

#1 387.5 F

#2 386.9 F

B34465

#01 30 m

S.00002 09.50

#1 388.9 F

#2 388.1 F

(24)

Job Number: 34465

Part Number: D2144

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D2144 Rev: ①

28 8

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/01/16

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FAB RESOURCE 1

1- Weld corner as per Dwg D2144 & QSI 004

2- Grind flush

FL

FL 08 01 16

(24)

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

10 08-01-17 (24)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/01/17 (24)

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

BK

08-01-23

(24)

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

10 8/01/04

(24)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57198A

10 8/01/24

(24)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 9/7/2007 10:14:56 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE BRACKET, GAS SPRING

Job Number: 34465

Part Number: D2144

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



08.01.24  
JA

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mi 2008/1/24

W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	34465
<b>Description:</b> Hinge Bracket		<b>Part Number:</b>	D2144
<b>Inspection Dwg:</b> D2144 <b>Rev:</b> D		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.381	+/-0.010	3.384	✓		Height gage	
3.022	+/-0.010	3.022	✓		Vern	
2.468	+/-0.010	2.470	✓		Height gage	
1.913	+/-0.010	1.911	✓		Vern	
1.555	+/-0.010	1.551	✓		Height gage	
4.126	+/-0.010	4.130	✓		Vern	
3.465	+/-0.010	3.462	✓		Vern	
0.340	+/-0.010	0.338	✓		Vern	
0.625	+/-0.010	0.630	✓		Height gage	
1.000	+/-0.010	0.996	✓		Vern	
1.083	+/-0.010	1.083	✓		Vern	
1.660	+/-0.010	1.658	✓		Vern	
2.312	+/-0.010	2.311	✓		Vern	
2.844	+/-0.010	2.842	✓		Vern	
3.294	+/-0.010	3.296	✓		Vern	
Ø0.257	+0.006/-0.001	Ø0.261	✓		Vern	
Ø0.171	+0.005/-0.001	Ø0.173	✓		Vern	
Ø0.320	+0.006/-0.001	Ø0.322	✓		Vern	
0.354	+/-0.010	0.353	✓		Vern	
0.063	+/-0.010	0.059	✓		Vern	

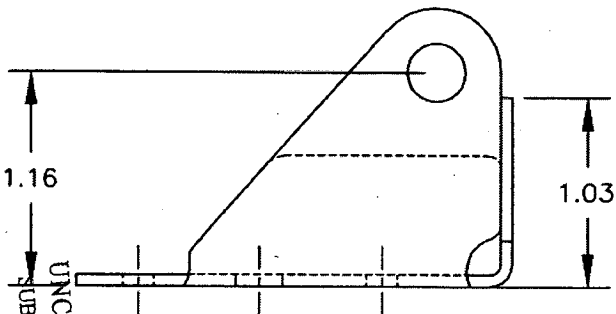
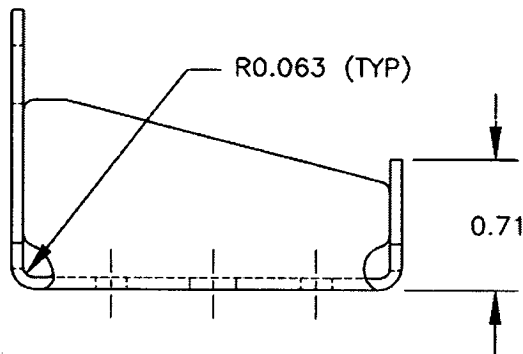
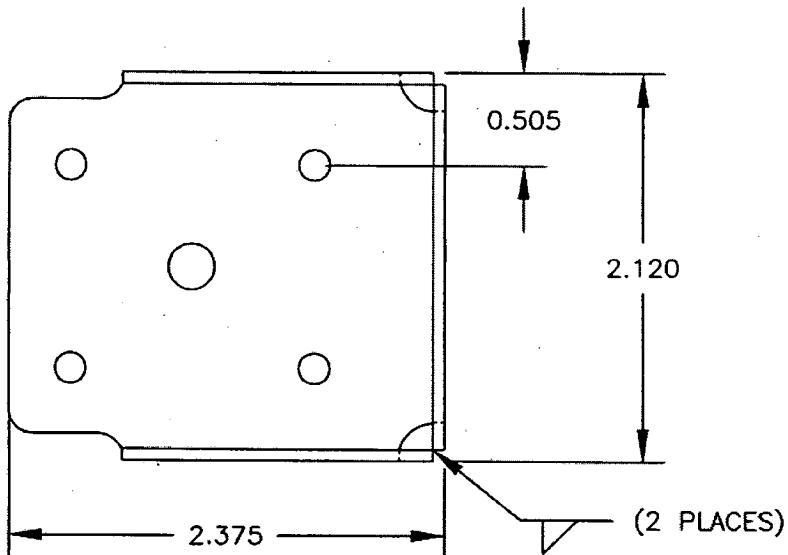
<b>Measured by:</b>	SAD	<b>Audited by:</b>	Er	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	07/09/08	<b>Date:</b>	07/09/10	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.31	New Issue	KJ/JLM	



RELEASED  
98.10.15 KE

DESIGN	BW	DRAWN BY	KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	KE	APPROVED	KE	REV. D
DATE	98.10.08	TITLE	HINGE BRACKET	SHEET 1 OF 2
				SCALE 1:1
A	95.03.17	NEW ISSUE		
C	96.06.05	FLAT PATTERN LAYOUT ADDED		
D	98.10.08	UPDATED DIMS AFTER BEND (TSR A917)		



FINISH: POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
WELD PER DART QSI 004

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ENGINEERING

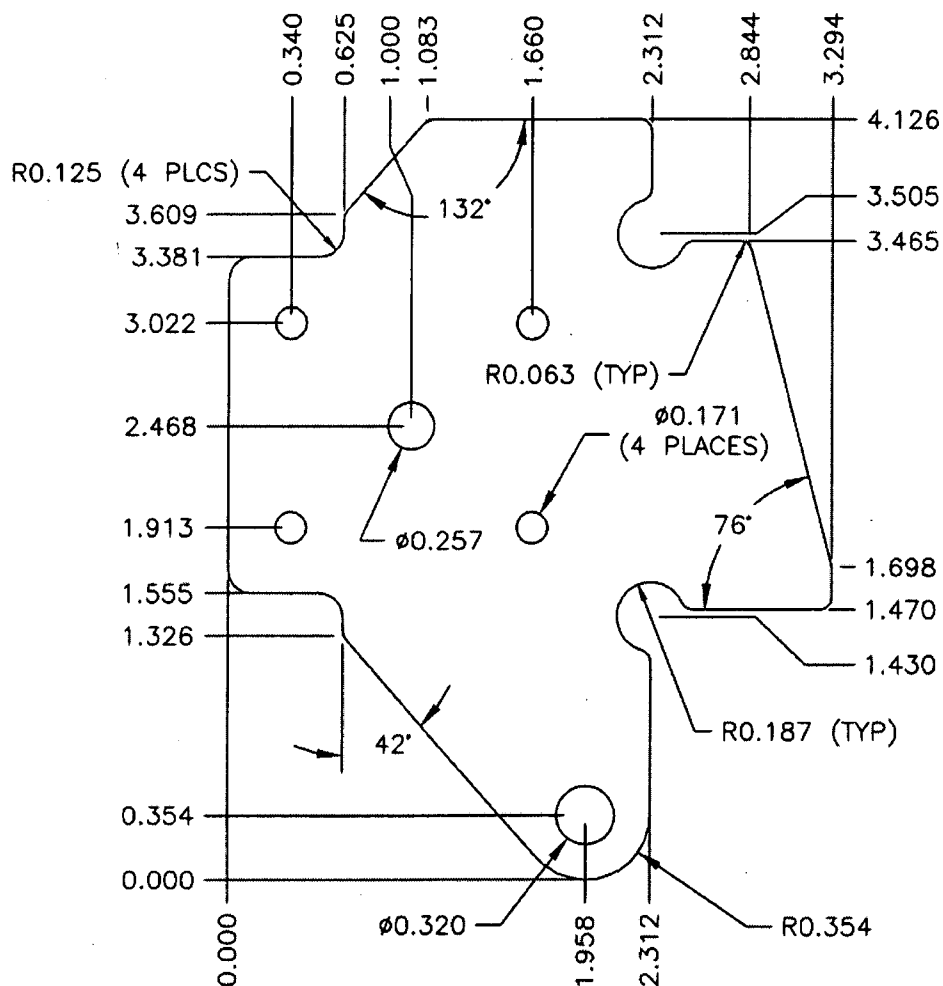
WORK ORDER  
NO. 34465





DESIGN BW	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2144	REV. D SHEET 2 OF 2
DATE 98.10.08	TITLE HINGE BRACKET		SCALE 1:1

RELEASED  
98.10.15 KE



D2144 FLAT PATTERN

MATERIAL: AISI 304/316-2B SS, 0.063 THICK  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES

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NO. 34465